

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020122**Date Inspected:** 23-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Jiao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

BAY 13

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08275 from ZPMC for Bay 13. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG Grillage. The weld designations reviewed are as follows.

SA7038C-223, 231, 235, 262

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zheng Zhi Wei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Component: Grillage

PCMK: SA7038C

Weld Number: 004

Welder: 066733

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2231-ESAB

Component: Grillage

PCMK: SA7038C

Weld Number: 001

Welder: 037723

WPS-B-T-2231-ESAB

BAY 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Zheng Zhi Wei, and Li Ping

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Component: Edge Plate

PCMK: SEG3019AG

Weld Number: 001

Welder: 066763

WPS-B-T-2233-ESAB

Component: I Rib

PCMK: SP3020A2

Weld Number: 371, 373

Welder: 068445

WPS-B-T-2233-ESAB

Component: I Rib

PCMK: SP3020A2

Weld Number: 374, 376

Welder: 037780

WPS-B-P-2213-TC-U4b-FCM-1

Component: I Rib

PCMK: SP3020A2

Weld Number: 396

Welder: 067765

WPS-B-P-2214-TC-U4b-FCM-1

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 08272 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG. The weld designations reviewed are as follows.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

SEG3019L-001-077, 088

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Combs,Dennis | Quality Assurance Inspector |
| Reviewed By: | Riley,Ken | QA Reviewer |
